



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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Don - Airbus

D350-591-312
Job Sheet 191894-B



Part No: D350-591-312

Job Qty: 3 pcs

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/4/19

Job Tracking No:

Due Date: 6/3/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
230	Handfinish - 3-1- WingWalk-B4B	3 pcs	6/3/19	6/3/19	0.00	0.56	Handfinish - 3 - 1 - B4B	
							Handfinish - 3 - 2 - B4B	
							Handfinish - 3 - 3 - B4B	
							Handfinish - 3 - 4 - B4B	
							Handfinish - 3 - 5 - B4B	
240	QC 3	3 pcs	6/3/19	6/3/19	0.00	0.00	QC 3 - 10	
							QC 3 - 13	
							QC 3 - 15	
							QC 3 - 17	
							QC 3 - 18	
							QC 3 - 2	
							QC 3 - 26	
							QC 3 - 28	
							QC 3 - 3	
							QC 3 - 30	
							QC 3 - 34	
							QC 3 - 36	
							QC 3 - 41	
							QC 3 - 51	
							QC 3 - 58	
250	Packaging 1-1 - Pick Kit - B4B	3 pcs	6/3/19	6/3/19	0.00	0.00	Packaging 1 - 1 - B4B	
							Packaging 1 - 2 - B4B	
							Packaging 1 - 3 - B4B	
							Packaging 1 - 4 - B4B	
							Packaging 1 - 5 - B4B	



Container No: S187329



Part: D350-591-312

Job No: 191894-B

Serial No/Batch: S184155

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issue 11, FAA STC SH967NE 04/12/21, BRAZIL 1

Dart Aerospace Ltd.
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CANADA
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DAS
40
9-89
JUN 04 2019

				Packaging 1 - 6 - B4B	
				Packaging 1 - 7 - B4B	DAS
				Packaging 1 - 8 - B4B	28
				Packaging 1 - 9 - B4B	9-89
				Packaging 1 - 10 - B4B	
				Packaging 1 - 11 - B4B	
				Packaging 1 - 12 - B4B	
				Packaging 1 - 13 - B4B	
				Packaging 1 - 14 - B4B	
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				Packaging 1 - 16 - B4B	
				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36 - B4B	
260 QC 4	3 pcs	6/3/19	0.00 0.00	QC 4 - 26	
				QC 4 - 28	
				QC 4 - 42	
				QC 4 - 58	SMB 19/11/14
				QC 4 - 6	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
270 Packaging 3-1 - Stock - B4B	3 pcs	6/3/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	SMB 19/11/14
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
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				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
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				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
275 DC - 1 - B4B	3 pcs	6/3/19	0.00 0.00	DC - 1 - B4B	21 JUL 04 2019
				DC - 2 - B4B	9-89
280 QC 21 - FG	3 pcs	6/3/19	0.00 0.00	QC 21 - FG - 21	DAS
				QC 21 - FG - 70	21 JUL 04 2019
				QC 21 - FG - 53	9-89

Part Op 230 - Wing Walk as per dwg QSI005 4.4 Batch _____
 Descriptions: 240 - QC3- Inspect Part Finish
 250 - pick kit
 260 - QC4- 100% Inspect kits for completeness
 270 - Identify and pack for shipping as per PPPD350-591-312 Location FG109
 275 - Document Control - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001
 280 - QC21- Final Inspection - Work Order Release

fs/109

010184

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-35A	Bolt	6 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5158557
AN4-13A	Bolt	24 Ea (8 ea)	250-Packaging 1-1 - Pick Kit - B4B	5158578
AN5-36A	Bolt	6 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5167407
D2230-3	Mounting Lug	12 pcs (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	5174227
D2618	Bushing	6 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5146466
D2856-400-720	Abrasion Strip 4" X 7.20"	6 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5179063
D3235-1	Mounting Lug	6 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5190055
D3278-041	Support Assembly	3 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5173412
MS21042L3	Nut	6 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5157462
MS21042L4	Nut	24 Ea (8 ea)	250-Packaging 1-1 - Pick Kit - B4B	5183081
MS21042L5	Nut	6 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5149145
NAS1149D0363J	Washer	12 Ea (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	5162884
NAS1149D0463J	Washer	48 Ea (16 ea)	250-Packaging 1-1 - Pick Kit - B4B	5158585
NAS1149D0563J	Washer	12 Ea (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	5167648
DS19410-011				5194395

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
250-Packaging 1-1 - Pick Kit - B4B	AN3-35A	6	448	0
	AN4-13A	24	794	0
	AN5-36A	6	135	0
	D2230-3	12	169	0
	D2618	6	165	0
	D2856-400-720	6	114	0
	D3235-1	6	106	0
	D3278-041	3	35	0
	MS21042L3	6	1,860	0
	MS21042L4	24	2,126	0
	MS21042L5	6	707	0
	NAS1149D0363J	12	1,414	0
	NAS1149D0463J	48	3,383	0
	NAS1149D0563J	12	2,788	0

Part Specifications
Specifications could not be found.

Plex 6/4/19 1:01 PM dart.lacelle.linda



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D350-591-312
Job Sheet 191894



Part No: D350-591-312

Job Qty: 10 pcs

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/11/19

Job Tracking No:

Due Date: 6/3/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Steps - 1	10 pcs	6/3/19		0.00	10.00	Large Fab - 1		SLA
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
120	QC 9	10 pcs	6/3/19		0.00	0.00	QC 9 - 10		DAS 43 9-89
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
130	QC 5	10 pcs	6/3/19		0.00	0.00	QC 5 - 10		DAS 43 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		

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				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
140 Handfinish - 1-1 Chemical-B4B	10 pcs	6/3/19	0.00 1.87	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	MAY 28 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 7	10 pcs	6/3/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	

3/11/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	MAY 2 8 2019
					QC 7 - 59	
					QC 7 - 6	68-6 DAS
					QC 7 - 60	12 MAY 2 8 2019 24
					QC 7 - 9	SVD MAY 2 8 2019 9-89
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
180 Large Fab - Steps - 2 - B4B	10 pcs	6/3/19	0.00 10.00		Large Fab - 1 - B4B	
					Large Fab - 10 - B4B	SC
					Large Fab - 2 - B4B	
					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
190 QC 10	10 pcs	6/3/19	0.00 0.00		QC 10 - 10	
					QC 10 - 18	
					QC 10 - 24	DAS
					QC 10 - 43	24 MAY 3 0 2019
					QC 10 - 50	9-89
					QC 10 - 58	
					QC 10 - 9	
200 QC 5	10 pcs	6/3/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	DAS
					QC 5 - 42	24 MAY 3 0 2019
					QC 5 - 43	9-89
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
210 Handfinish - 1-2- Chemical-B4B	10 pcs	6/3/19	0.00 1.87		Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	★ MAY 3 0 2019
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 -	

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						B4B	
						Handfinish - 1 - 8 - B4B	
						Handfinish - 1 - 9 - B4B	
						Handfinish - 1 - 10 - B4B	
						Handfinish - 1 - 11 - B4B	
						Handfinish - 1 - 12 - B4B	
						Handfinish - 1 - 13 - B4B	
						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
220 Powdercoat - 1 White Gl(A)-B4B	10 pcs	6/3/19	0.00	2.98	Powdercoat - 1 - B4B		
					Powdercoat - 2 - B4B		
					Powdercoat - 3 - B4B		
					Powdercoat - 4 - B4B		
230 Handfinish - 3-1- WingWalk-B4B	10 pcs	6/3/19	0.00	1.87	Handfinish - 3 - 1 - B4B		
					Handfinish - 3 - 2 - B4B		
					Handfinish - 3 - 3 - B4B		
					Handfinish - 3 - 4 - B4B		
					Handfinish - 3 - 5 - B4B		
240 QC 3	10 pcs	6/3/19	0.00	0.00	QC 3 - 10		
					QC 3 - 13		
					QC 3 - 15		
					QC 3 - 17		
					QC 3 - 18		
					QC 3 - 2		
					QC 3 - 26		
					QC 3 - 28		
					QC 3 - 3		
					QC 3 - 30		
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					QC 3 - 36		
					QC 3 - 41		
					QC 3 - 51		
					QC 3 - 58		
					QC 3 - 59		
					QC 3 - 6		
					QC 3 - 68		
						Plex 3/11/19 3:24 PM Dart.lajeunesse.marie	

				QC 3 - 9		
				QC 3 - 40		
250	Packaging 1-1 - Pick Kit - B4B	10 pcs	6/3/19	0.00	0.00	Packaging 1 - 1 - B4B
						Packaging 1 - 2 - B4B
						Packaging 1 - 3 - B4B
						Packaging 1 - 4 - B4B
						Packaging 1 - 5 - B4B
						Packaging 1 - 6 - B4B
						Packaging 1 - 7 - B4B
						Packaging 1 - 8 - B4B
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						Packaging 1 - 32 - B4B
						Packaging 1 - 33 - B4B
						Packaging 1 - 34 - B4B
						Packaging 1 - 35 - B4B
						Packaging 1 - 36 - B4B
260	QC 4	10 pcs	6/3/19	0.00	0.00	QC 4 - 26
						QC 4 - 28
						QC 4 - 42
						QC 4 - 58
						QC 4 - 6
						QC 4 - 69
						QC 4 - 9
270	Packaging 3-1 - Stock - B4B	10 pcs	6/3/19	0.00	0.00	QC 4 - 46
						Packaging 3 - 1 - B4B
						Packaging 3 - 2 - B4B
						Packaging 3 - 3 - B4B
						Packaging 3 - 4 - B4B
						Packaging 3 - 5 - B4B
						Packaging 3 - 6 - B4B
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					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
275 DC - 1 - B4B	10 pcs	6/3/19	0.00	0.00	DC - 1 - B4B	
					DC - 2 - B4B	
280 QC 21 - FG	10 pcs	6/3/19	0.00	0.00	QC 21 - FG - 21	
					QC 21 - FG - 70	
					QC 21 - FG - 53	

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod _____ 3-Grind End Plate flush

120 - QC9- Inspect visual per QSI004- Fusion Welds

130 - QC5- Inspect part completeness to step on W/O

140 - Chemical Conversion Coat per QSI005 4.1

150 - QC7-Inspect Chemical Conversion Coat

180 - Weld per dwg A/R Aluminum rod Batch: _____ 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod _____ 6-Grind End Plate flush 7-Install last rivet as per Dwg.

190 - QC10- Inspect visual per QSI004- ground welds

200 - QC5- Inspect part completeness to step on W/O

210 - Chemical Conversion Coat per QSI005 4.1

220 - (White Gloss(Ref 4.3.5.1) per QSI005 4.3-Align START TIME: 11:25 OVEN TEMPERATURE: 300

FINISH TIME: 11:25

230 - Wing Walk as per dwg QSI005 4.4 Batch 5185147

240 - QC3- Inspect Part Finish

250 - pick kit

260 - QC4- 100% Inspect kits for completeness

270 - Identify and pack for shipping as per PPPD350-591-312 Location FG109

275 - Document Control - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

280 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 pcs (2 ea)	110-Large Fab - Steps - 1	(20) 5125542
D3219-1	Plate	20 pcs (2 ea)	110-Large Fab - Steps - 1	(19) 5125731 / 5183873 (5)
D3272-1	Step	10 pcs (1 ea)	110-Large Fab - Steps - 1	(10) 5182037
D3065-041	Step Leg Assembly	10 pcs (1 ea)	180-Large Fab - Steps - 2 - B4B	5184424
D3066-1	Spacer	20 pcs (2 ea)	180-Large Fab - Steps - 2 - B4B	5128757 / 5183550
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab - Steps - 2 - B4B	5141237-2 / 5141237-8
AN3-35A	Bolt	20 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	
AN4-13A	Bolt	80 Ea (8 ea)	250-Packaging 1-1 - Pick Kit - B4B	
AN5-36A	Bolt	20 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	
D2230-3	Mounting Lug	40 pcs (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	
D2618	Bushing	20 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	
D2856-400-720	Abrasion Strip 4" X 7.20"	20 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	
D3235-1	Mounting Lug	20 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	
D3278-041	Support Assembly	10 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	
MS21042L3	Nut	20 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	
MS21042L4	Nut	80 Ea (8 ea)	250-Packaging 1-1 - Pick Kit - B4B	
MS21042L5	Nut	20 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	
NAS1149D0363J	Washer	40 Ea (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	
NAS1149D0463J	Washer	160 Ea (16 ea)	250-Packaging 1-1 - Pick Kit - B4B	
NAS1149D0563J	Washer	40 Ea (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D3067-1	20	193	0
	D3219-1	20	163	0
	D3272-1	10	0	0
180-Large Fab - Steps - 2 - B4B	D3065-041	10	11	0
	D3066-1	20	167	0
	MS20600-AD4W4	160	3,553	0
250-Packaging 1-1 - Pick Kit - B4B	AN3-35A	20	582	0
	AN4-13A	80	1,827	0
	AN5-36A	20	130	0
	D2230-3	40	135	0
	D2618	20	200	0
	D2856-400-720	20	186	0
	D3235-1	20	240	0
	D3278-041	10	3	0
	MS21042L3	20	3,879	0
	MS21042L4	80	3,600	0
	MS21042L5	20	749	0
	NAS1149D0363J	40	920	0
	NAS1149D0463J	160	7,242	0
	NAS1149D0563J	40	1,551	0

Part Specifications

Specifications could not be found.

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Change Record

PAGE 1 OF 2

Part Number: D350-591-311/-312 (EURO P/N: 704A 41 640 012/-011)

Description: HELI-ACCESS STEP, HIGH SKID, LONG STEP, LH/RH

[illegible]